

Work Order ID 71198

Thursday, June 23, 2011 12:36:28 PM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

8/6/27

JG CL 11-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E .

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

BB
OK11/06/24
11/06/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-6-24

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

xl

10/06/24

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0

BE 11/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M116945
Exp Date: 12/01/15
start time: 11:30 am
end time: 11/06/25Dr. 11/06/24
8:00

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: M112860 BE 11/06/25

6-Grind welds flush

BE 11/06/25

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

BE 11/06/25

8-Deburr Rivet holes.

BE 11/06/25

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.



3 11/06/27

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 W6/27



W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 ϕ 11-6-27.

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

10:10
320 OF
10:401X ϕ M 11/06/27

230



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 ϕ 11/06/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1 0 24 11/06/27

✓ 1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

✓ 1-Inspect for Foreign objects

✓ 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M117516
Exp Date: 12/01✓ 3-Install Wearplates as per Dwg D3507,
Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Scews where indicated on Dwg(Note #6)✓ A/R 241 Sika Flex Batch: M117516
Exp Date: 12/01✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M114189✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4
Batch: M117863

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
280 Packaging Packaging	Pick Kit Memo	0.00 0.00							
290 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

Dart Aerospace Ltd

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

6/23/27

11-06-27

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D135-751-011

Parent Item Name: Skidtube Installation



Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130 	Purchased	No					Each	1,485.000		38			
Insert													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST282				1485					
				117717				1485		138			
D3507-1-BENT 	Manufactured	No				120	Each	2.0000	1	1			
Skidtube Assembly EC135													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				2					
				62291				1					
				62292				1					
D3504-1 	Manufactured	No				170	Each	6.0000	2	2			
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				6					
				53742				6		2			

06/23/2011

W/O:		WORK ORDER CHANGES					
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Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each

26.0000

1

1



Crossbolt Spacer



BE 11/06/25

Location

Loc Qty

Loc Code

LG001

26

31232

6

53743

20

1

D3504-5 Manufactured No

170 Each

8.0000

2

2



Crossbolt Spacer



BE 11/06/25

Location

Loc Qty

Loc Code

LG001

8

53744

8

2

D3505-1 Manufactured No

170 Each

0.0000

1

1



Web



71214

BE 11/06/25

D3506-1 Manufactured No

190 Each

47.0000

4

4



Doubler



BE 11/06/25

Location

Loc Qty

Loc Code

ST063

47

51789

47

4

D3506-3 Manufactured No

190 Each

87.0000

2

2



Doubler



BE 11/06/25

Location

Loc Qty

Loc Code

ST063

87

51790

87

2

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Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3

Purchased

No

190

Each

2,846.000

12

12



Rivet



BE 11/06/25

Location

Loc Qty

Loc Code

ST321

2846

114538

2846

12

ALS4-1032-225

Purchased

No

260

Each

730.0000

1

1



Insert



11 11/06/27

Location

Loc Qty

Loc Code

ST282

730

110768

213

117717

517

x1

AN3C4A

Purchased

No

260

Each

2,494.000

31

31



BOLT



11 11/06/27

Location

Loc Qty

Loc Code

ST350

2494

117094

8

117313

2

117688

800

117795

500

117872

184

118012

500

118112

500

x31

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Shop Packet Print

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Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 260 Each 1,403.000 2 2
Bolt

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1396	
116419	28	
116549	54	
117343	500	
117508	14	x2
117764	300	
117872	500	

AN526C1032R10 Purchased No 260 Each 245.0000 2 2
Screw

Location	Loc Qty	Loc Code
FP-B	107	
108062	107	
ST327	100	
114494	100	
ST328	38	
110049	38	x2

AN960C10L NAS1149C0332 Purchased No 260 Each 0.0000 33 33
washer

11110078

(x33) ML u106127

W/O:		WORK ORDER CHANGES					
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Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011



Start Qty: 1.00

Required Qty: 1.00

D2965	Manufactured	No	260	Each	25.0000	1	1
							<u>22 1106127</u>
Cap, 105 Skidtube							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP006	25	
52057	25	<u>x1</u>

D2965-3	Manufactured	No	260	Each	3.0000	1	1
							<u>22 1106122</u>
Cap							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP005	3	
50560	2	
52282	1	<u>x1</u>

D3492-1	Manufactured	No	260	Each	68.0000	4	4
							<u>22 1106127</u>
Plug							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	68	
69531	8	<u>370689</u>
69819	60	<u>x4</u>

D3492-3	Manufactured	No	260	Each	60.0000	4	4
							<u>22 1106127</u>
Plug							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	60	
69822	60	<u>x4</u>

D3492-7	Manufactured	No	260	Each	0.0000	2	2
							<u>22 1106127</u>
Plug							

03492-047 / 328961 *

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:26 PM

Page 6

Work Order ID: 71198

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011



Start Qty: 1.00

Required Qty: 1.00

D3508-1	Manufactured	No	260	Each	12.0000	1	1
							<u>21 11/06/27</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP016	12	
<u>61020</u>	12	<u>VI</u>

D3508-3	Manufactured	No	260	Each	4.0000	1	1
							<u>21 11/06/27</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	4	
38527	1	
<u>67489</u>	3	<u>VI</u>

D3508-5	Manufactured	No	260	Each	6.0000	1	1
							<u>21 11/06/27</u>
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	6	
<u>67160</u>	6	<u>VI</u>

D3508-7	Manufactured	No	260	Each	11.0000	1	1
							<u>21 11/06/27</u>
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	11	
<u>67159</u>	5	<u>VI</u>
67739	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:26 PM

Page 7

Work Order ID: 71198

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/23/2011



Required Date: 7/4/2011

Start Qty: 1.00



Required Qty: 1.00

D3558-1	Manufactured	No	260	Each	12.0000	1	1
							<u>XL u106127</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP014	12	
<u>42533</u>	1	<u>XL</u>
50925	11	

D3558-3	Manufactured	No	260	Each	6.0000	1	1
							<u>XL u106127</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP014	6	
<u>67486</u>	6	<u>XL</u>

D3558-5	Manufactured	No	260	Each	14.0000	1	1
							<u>XL u106127</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP014	14	
<u>43244</u>	1	<u>XL</u>
50926	1	
67485	12	

D3558-7	Manufactured	No	260	Each	16.0000	1	1
							<u>XL u106127</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP014	16	
<u>67162</u>	16	<u>XL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:26 PM

Work Order ID: 71198

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

294.0000

2

2



O-RING



Jul 11/06/27

Location

Loc Qty

Loc Code

FP-A

294

103697

294

x2

NAS1611-010

Purchased

No

260

Each

214.0000

4

4



O-RING



Jul 11/06/27

Location

Loc Qty

Loc Code

FP

96

117460

16

118077

80

FP-A

118

110915

95

115589

23

x4

NAS1611-013

Purchased

No

260

Each

192.0000

4

4



O-RING



Jul 11/06/27

Location

Loc Qty

Loc Code

FP

187

117291

47

117887

140

FP-A

5

116582

5

y4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

Thursday, June 23, 2011 12:36:26 PM

Work Order ID: 71198

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

280

Each

2,494.000

8

8



BOLT

Location

Loc Qty

Loc Code

ST350

2494

117094

8

117313

2

117688

800

117795

500

117872

184

118012

500

118112

500

AN960C10L

NA\$1149C0332
R

Purchased

No

280

Each

0.0000

8

8



washer

D3512-1

Manufactured

No

280

Each

4.0000

2

2



Wearplate

Location

Loc Qty

Loc Code

ST500

4

70863

4

Thursday, June 23, 2011 12:36:26 PM

Shop Packet Print

Page 9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:

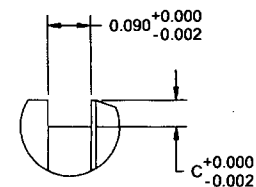
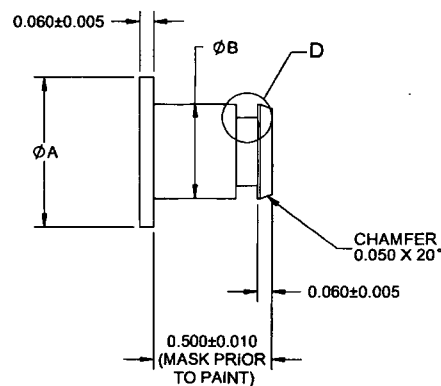
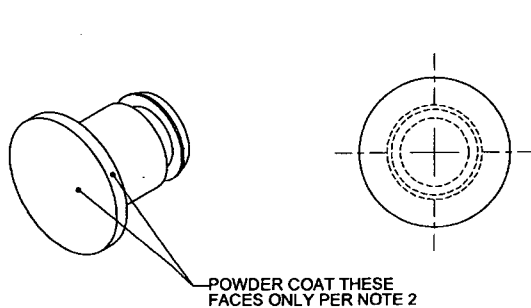
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71198

C211/06/23

RELEASED
2011-05-30

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CART11-048)	AJS	11.05.24
C	ADD -048/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JFB	DRAWING NO.	REV. D
MFG. APPR.	JFB	D3492	SHEET 1 OF 2
APPROVED	ALP	TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30

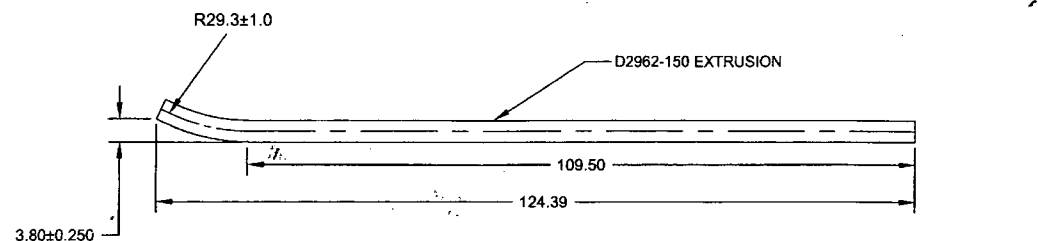
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	J.F.S.	D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

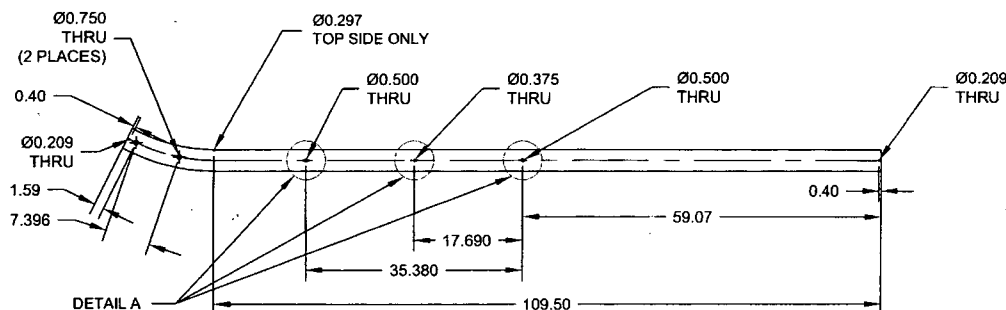
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

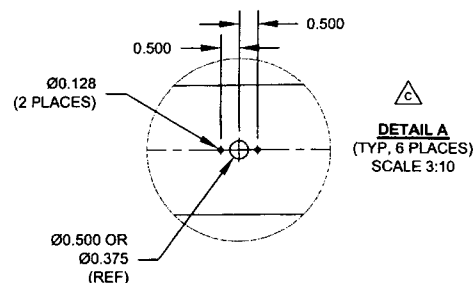
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	JC	
DRAWN	JC		
CHECKED	BA		
MFG. APPR.	BA		
APPROVED	BA		
DE APPR.	BA		
DATE	07.09.19		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3507 TITLE EC 135 SKIDTUBE REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC			



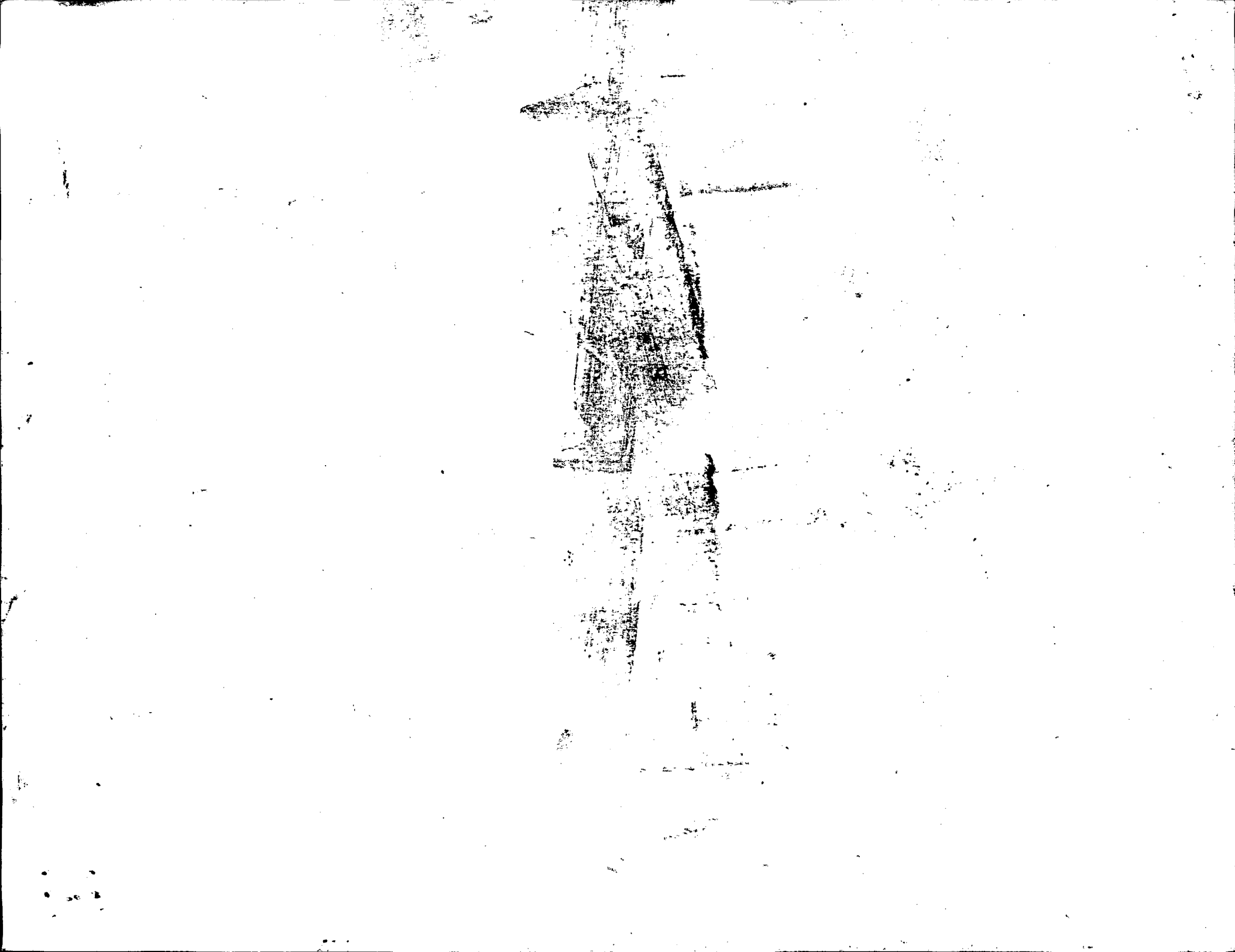
D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



RELEASED
07-11-16-14



NO. 257

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B6664
Part number: D135-751-011
Description: 135
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Lewis Date of Test Coupon 11-06-22
Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld